



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

May 10
D2565-209
Job Sheet 176547



Part No: D2565-209

Job Qty: 4 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/18

Job Tracking No:

Due Date: 5/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP: D 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/10/18	5/10/18	0.00	0.00	Start Up Small Fab-4		<i>M.L.</i>
100	Brake NC	4 pcs	5/10/18	5/10/18	1.37	0.21	Brake NC 3		<i>M.L.</i>
110	Small Fab	4 pcs	5/10/18	5/10/18	0.00	0.65	Small Fab		<i>M.L.</i>
120	QC	4 pcs	5/10/18	5/10/18	0.00	0.00	QC5		<i>38</i>
130	Powdercoat	4 pcs	5/10/18	5/10/18	0.00	0.29	Powdercoat2		<i>BEB 18-05-15</i>
140	QC	4 pcs	5/10/18	5/10/18	0.00	0.00	QC3		<i>38</i>
150	Packaging	4 pcs	5/10/18	5/10/18	0.00	0.00	Packaging3	<i>5735</i>	<i>38</i>
160	QC21-SA	4 Ea	5/10/18	5/10/18	0.00	0.00	QC21		<i>MAY 16 2018</i>

Part Op 100 - Punch as per Dwg D2565 using DT 8313

Descriptions: 110 - Deburr

M138760 130 - START TIME: *2:30*

TEMP: 400°

FINISH: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	5.1332 ft (1.2833 ea)	90-Start up Operation	

5000958 X 1.3

5017137 X 1.3

5053527 X 2.6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.750W.049	5	68	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :					
Misidentified ☐	☐ Past Due						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wd. _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐		
		MRB (QSI042) Approval		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		

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DART
AEROSPACE

Container No: S071024
Part: D2565-209
Job No: 176547
Serial No/Batch: S071024
Revision:
Inspector:

Date: 05/14/18

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Positioned Wrong
☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Outside Dimensions
☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Over/Under tolerance
☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Incorrect
☐	Crushing	☐	Countersink	☐	Off-set	☐	Part Lost/Missing
☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Part Moved
☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Drawing
☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Finish
☐		☐		☐		☐	Misread
☐		☐		☐		☐	Turning Sequence